SIEMENS

MAMMOMAT 300/3000

SP

Service

Repair Instructions

Object table locking

Kit part No.;64 31 675 X041E

© Siemens-Elema AB 1997
The reproduction, transmission or use of this document or its contents is not permitted without express written authority. Offenders will be liable for damages. All rights, including rights created by patent grant or registration of a utility model or design, are reserved.

Print No.: SPB7-120.091.05.01.02

English
Doc. Gen. Date: 04.97
64 27 764

Purpose

The use of different materials at the object tables (aluminium) and the locking device (steel) could cause excessive wear of the object tables, with the consequence of having to replace the complete object table.

Therefore a kit was designed that on the one hand reduces the stress to the object tables and on the other hand repairs already existing damages.

A new design of the object table locking device, with roller, has been introduced in production at the end of 1996.

Special tools/Documents

- Cleaning alcohol
- Glue, Siemens P/N 15 88 230 (Araldite 2012)
  NOTE; Araldite is a dangerous material. When working with Araldite, pay attention to local regulations and safety notes. Disposal according to official regulations.
- Set of punches

Contents of repair kit

The repair kit 64 31 675 contains the following parts.

Pos.	Amount	Name
1	2	Locking arm
2	2	Spring pin
3	5	Reinforcement
4	1	Repair Instruction German (64 27 772)
5	1	Repair Instruction English (64 27 764)

Procedure

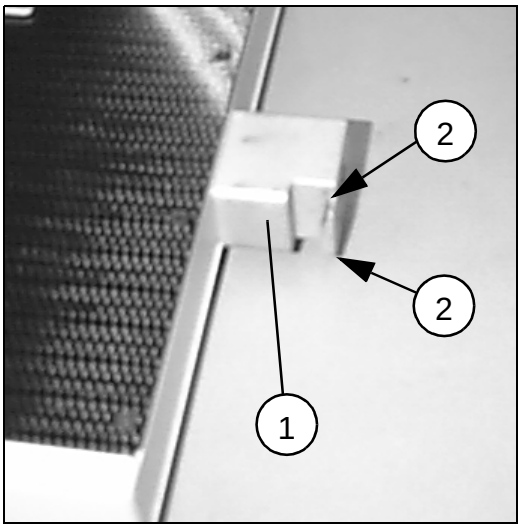

Fig. 1

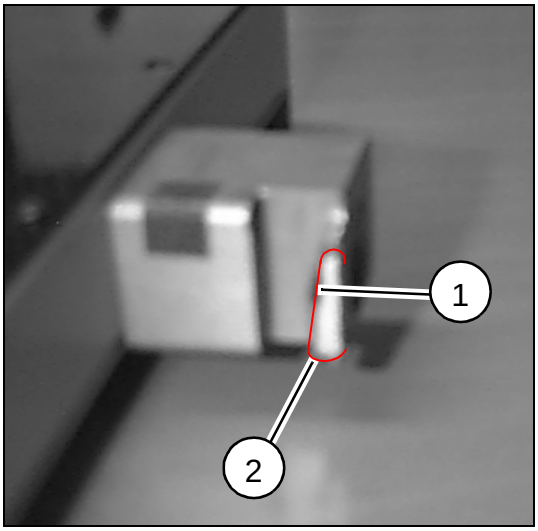

Fig. 2

- Check all existing object tables, for wear of the aluminium block (1/Fig. 1).
- If worn tables are found, remove approx. 0.5 mm at the top and bottom of the aluminium block by using a file (2/Fig.1) Also file the inner surface of steel reinforcement to get a rough surface.
- Clean the block and steel reinforcement (alcohol).
- Prepare 2 component glue and fill out existing gaps, also apply some glue to the whole contact surface of the block and steel reinforcement (1/Fig.2).
- Mount steel reinforcement (2/Fig.2) and remove excessive glue.
- Repeat this procedure on all defective object tables

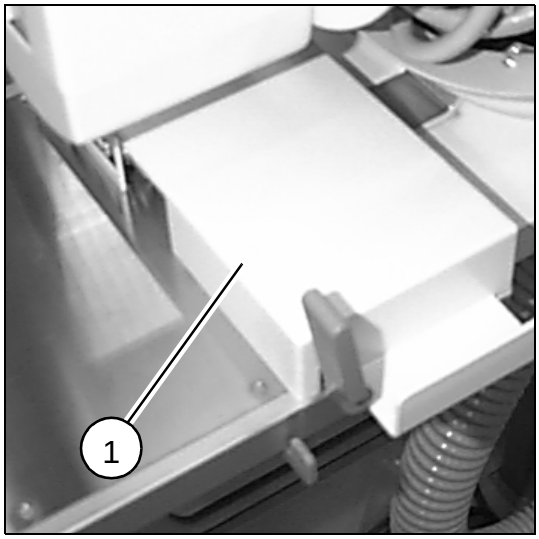

Fig. 3

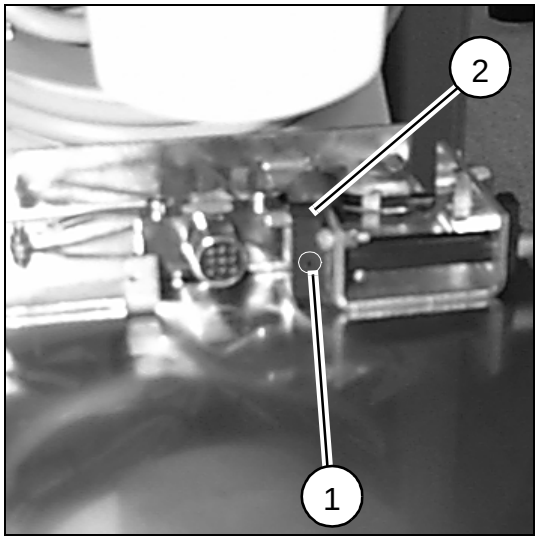

Fig. 4

- Remove base plate cover (1/Fig.3)
- Remove spring pin by using a punch (1/Fig.4)
- Replace existing locking device (2/Fig.4)
- Install cover (1/Fig.3)
- Repeat this procedure for second wing (only MAMMOMAT 3000)

Final tests

After the glue has been allowed to dry:

- Install all existing object tables at all base plates and check that the locking is smooth and the object table is firmly locked in place.

Changes to previous version

n.a.